

shp Jan. 16

Work Order ID 78104

78104

Page 1

December-28-11 3:34:20 PM

Item ID: D3964-3KGY

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Light Cover w/ Ducts

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 11/12/29

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3964

A-~~PROTO~~ *h*

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

h

12/01/10

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

x2

h

12/01/10

Temp: 150°F

Time IN: 7:00 pm

Time OUT: 5:00 am

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78104

Page 2

N900040100

Setup Start *NS1*

Stop ***NS2***

*** 1 ***

*** 1 ***

Reference:

Run Start *NR1*

Stop *NR2*

110

0.00

110

0.00

Thermoform

Memo

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA066 using tool DT9358

Dwg Rev: A

Folio Rev: B

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

0.00

QC

Quality Control

Memo

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00

130

0.00

QC

Quality Control

W/O: 78104		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3964-3 K67 PAR #: 12-153 Fault Category: _____ NCR: Yes ☒ No ☐ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.01.12	110	<u>00.125</u> HOLE DIMS CHANGED SLIGHTLY. REASON: MOLD DIDN'T HAVE ANY MARKINGS. DASH REQUIRED UPDATE PER MOLD.	<u>12.01.12</u> <u>Q51042</u>	ACCEPTABLE. HOLE PER TRANSFER PERIOD FROM D3964-3 TO OTHER PARTS ON INSTALL.	<u>12/1</u>	<u>12/01/12</u> <u>Q51042</u>	<u>12/01/12</u> <u>Q51042</u>	<u>12/01/12</u>

NOTE: Date & initial all entries

78104

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 28/12/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 16/01/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0,00

140

0.00

HandThermo

Memo

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

0.00

150

0.00

QC

Memo

Quality Control

Complete FAI document

0.00

160

0.00

QC

Memo

Quality Control!

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78104

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Page 4

Item ID: D3964-3KGY

Accept

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Setup Start ***NS1***

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Stop ***NS2***

Item Name: Light Cover w/ Ducts

Start Date: 28/12/2011 Start Qty: 1.00

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Required Date: 16/01/2012 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ISO</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/16

②

12/1/17

R120416
②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-28-11 3:34:24 PM

Page 1

Work Order ID: 78104

78104

Parent Item: D3964-3KGY

D3964-3KGY

Parent Item Name: Light Cover w/ Ducts

Start Date: 28/12/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MKYD6185S.080-P3-
52068

Purchased

No

sf

1,011.893

1

MKYD6185S 080-P3-52068

**

Kydex steel grey

Location

therm

111807

119476

Loc Qty

1011.893107

10.4896282

1001.40348

Loc Code

2 sg ft

Sh
12/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

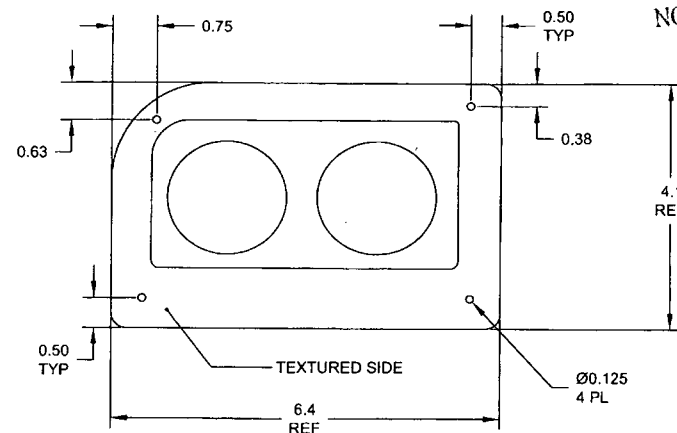
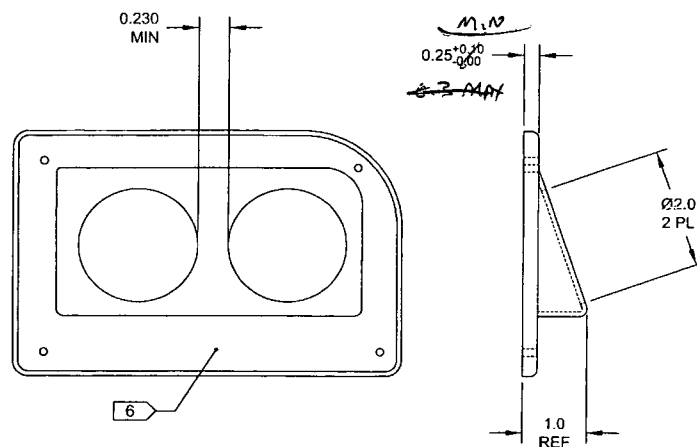
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT WORK
NO. 78104



D3964-1 LIGHT COVER W/DUCTS

RELEASED
09/06/22

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.08 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9357 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.040" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3964-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3964-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	09.06.22
DESIGN		BY	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3964
REV. A
SHEET 1 OF 2
TITLE LIGHT COVER W/DUCTS (206 L3/L4)
SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

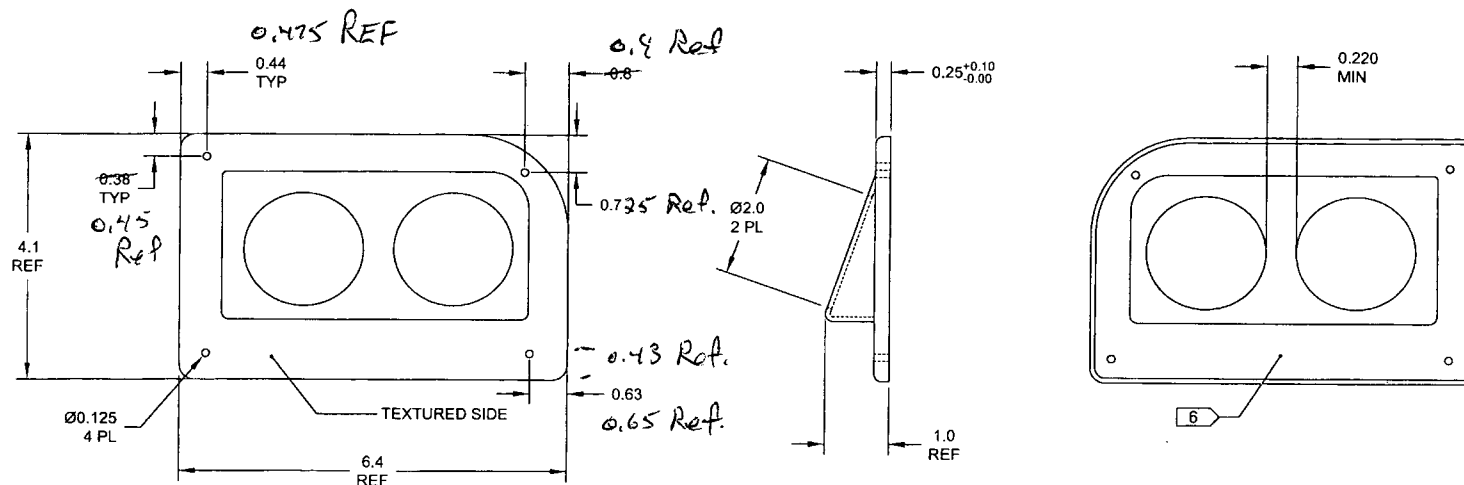
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

781 04



D3964-3 LIGHT COVER W/DUCTS

RELEASED
27/6/15

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.08 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9358 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.040" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3964-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3964-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	RA	DART AEROSPACE LTD	
DRAWN	RA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO.	REV. A
MFG. APPR.	RA	D3964	SHEET 2 OF 2
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	LIGHT COVER W/DUCTS (206 L3/L4)	NTS
DATE	09.06.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 78104
Description:	Part Number: D3964-SKGY
Inspection Dwg: D3964 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than $\frac{1}{8}$ "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: OK **Date:** 12/01/10

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.4	Ref	6.375"	✓		TAPE DL-01	
4.1	Ref	4.1"	✓		TAPE DL-01	
0.290	MIN.	0.290"	✓		USE DL-02	
2.0"	± 0.012 -0.001	2.008"	✓		USE DL-02	
0.125"	± 0.004 -0.001	0.125"	✓			
0.44"	± 0.030	0.428"		✓		See NCR
0.38"	± 0.030	0.435"		✓		See NCR
0.63"	± 0.030	0.65"	✓	✓		
0.8"	± 0.100	0.825"	✓			
0.7"	± 0.100	0.715"	✓			
0.25"	± 0.10 -0.00	0.275"	✓			

Measured by: OK **Date:** 12/01/12

Audited by: S **Date:** 12/01/13

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10-04-14